

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021183**Date Inspected:** 21-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Cross Beam CB14

This QA Inspector witnessed Magnetic Particle Testing (MT). All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the Deck Panel to Side Panel weld joint of CB14 East Side. ABF notification No: 07212010-1, Item # 1.

The weld designations reviewed are as follows:

CB202A-013-002

Cross Beam CB14

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the SP to DP – E weld. ABF notification No: 07212010-1, Item # 1.

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ABF Report No: UT-9E-057

The weld designations reviewed are as follows:

CB202A-014-002

OBG Segment 9BW-9CW

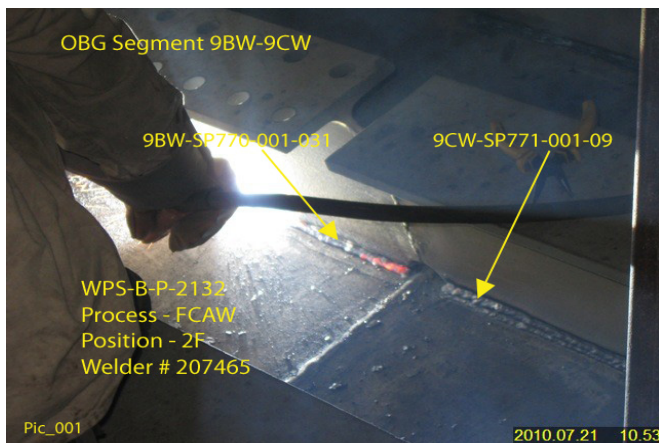
Flux Core Arc Welding (FCAW) in the 2F position of Side Panel 'T' ribs holdback weld at Counterweight side. Weld # 9BW-SP770-001-031 and 9CW-SP771-001-09. The welder is identified as 207465. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2132. See attached photograph Pic\_001

OBG Segment 9BW-9CW

Shielded Metal Arc Welding (SMAW) in the 4G position of EP to DP holdback weld of Counterweight side. Weld # 9BW-CA061-002 and 9CW-CA059-006. The welder is identified as 068097. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_002.

Bay 14 – OBG Segment 12BW

Shielded Metal Arc Welding (SMAW) in the 3G position of Cross Beam side LD to DP Diaphragm at PP114W. Weld # DP3054-001-017. The welder is identified as 037780. ZPMC Quality Control (QC) is identified as Wang Weiming. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-Repair.



## Summary of Conversations:

No relevant conversations reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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